

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015898**Date Inspected:** 19-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – Document No: 006229

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13AW bottom plate. The weld designations reviewed are as follows:

1. BP3074-001-001, 002, 004, 005

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This QA inspector observed ZPMC qualified welding personnel identified as 250050 perform Submerged Arc Welding (SAW) Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3033-001-004. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 045265 perform SAW Welding on Longitudinal Diaphragm of OBG Segment 13AW, weld joint identified as LD3031-001-003. ZPMC QC is identified as Mr. Tao Wei. The welding parameters as measured using QC's calibrated instruments appeared to be

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in general compliance with WPS-B-T-2221-B-U3c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 250050 perform SAW Welding on Longitudinal Diaphragm of OBG Segment 13CW, weld joint identified as LD3033-001-002. ZPMC QC is identified as Mr. Xia Chun Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 045265 perform SAW Welding on Longitudinal Diaphragm of OBG Segment 13AW, weld joint identified as LD3033-001-002. ZPMC QC is identified as Mr. Tao Wei. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-U3c-S-2.

This QA observed ZPMC personnel performing UT inspection on Longitudinal Diaphragm to Longitudinal Diaphragm of OBG Segment 13AW. The joints number are identified as LD3032-001-001, 002, LD3035-001-001, 002, 003. See the attached picture.

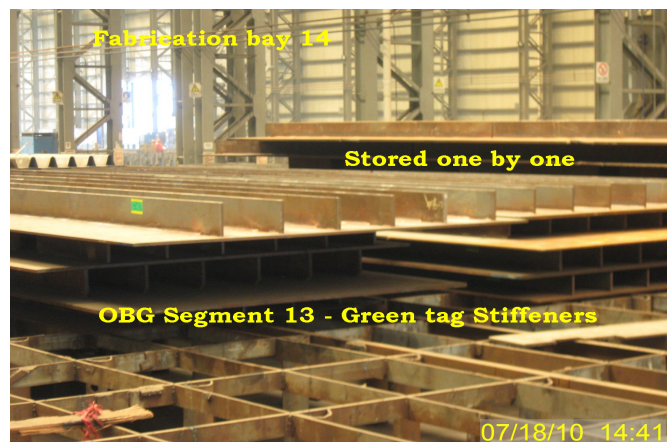
OBG Segment 12BW

This QA inspector observed ZPMC qualified welding personnel identified as 067183 perform SMAW Welding on lifting leg of OBG Segment 12BW, weld joint identified as SEG3005E-240. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

OBG Segment 12CW

This QA inspector observed ZPMC qualified welding personnel identified as 045263 perform SMAW welding on corner assembly of OBG Segment 12CW, weld joint identified CA3011-003. ZPMC QC is identified as Mr. Wang Wei Ming. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2211-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
